

Work Order ID 60560

Wednesday, July 14, 2010 9:17:32 AM



Page 1

Item ID:	D3859-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Wearplate				Stop	
Start Date:	7/14/2010	Start Qty:	6.00			
Required Date:	7/22/2010	Req'd Qty:	6.00			
Reference:						

Approvals:	Process Plan:	<u>PK</u>	Date:	<u>10-7-14</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
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100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3859 <input checked="" type="checkbox"/> Dwg Rev: <u>A</u> <input type="checkbox"/> Prog Rev: <u>A</u> <input type="checkbox"/> 2-								
304 .063	Deburr if necessary								

D-BURL B 10-7-21
-AWM
10-07-27 (8)

(8)

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B 10-7-21

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

8/10/08/09

(XS)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3859-041

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 7/14/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	1-Weld D3009-3 cups as per dwg D3859 <input type="checkbox"/> A/R 316L stainless steel rod Batch: <u>M108160</u> <input type="checkbox"/> 2-Weld hard facing as per Dwg D3859 <input type="checkbox"/> A/R 2059B Hard Coat rod Batch: <u>M114818</u> <input type="checkbox"/> *****use DT9462 for welding*****								
140 	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									
150 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

AL 10-8-11 (XS)

XS BE 10-8-11
KE 10-08-11

Siolo 10/11

(XS)

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Required Date:	7/22/2010	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Powdercoat Powder Coating	Grey Sandtex(Ref.4.3.5.6) per QSI005 4.3 Memo START TIME: 2:30pm FINISH TIME: 3:00pm OVEN TEMPERATURE: 320°F	0.00 0.00		⇒ JH 10/08/11		8	0		
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				ml	10	08	11 (8)
180 Packaging Packaging	Identify as per dwg & Stock Location: 500 Memo	0.00 1.00				10/08/12	82	SP	

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Start Date: 7/14/2010 Start Qty: 6.00



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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/13

MF

10-8-12

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NOTE: Date & initial all entries

Picklist Print

Wednesday, July 14, 2010 9:17:36 AM

Page 1

Work Order ID: 60560

Parent Item: D3859-041

Parent Item Name: Wearplate



Start Date: 7/14/2010

Required Date: 7/22/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 09-02-03 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	51.5039	0.85	5.1	6.8	18 10-7-21	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT		51.50389474						⑧	
				111323		0							
				114799		51.5038947				114799			
D3009-3 Cup		Manufactured	No			130	Each	329.0000	6	36		12 10-8-11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		329							
				42377		329				48			

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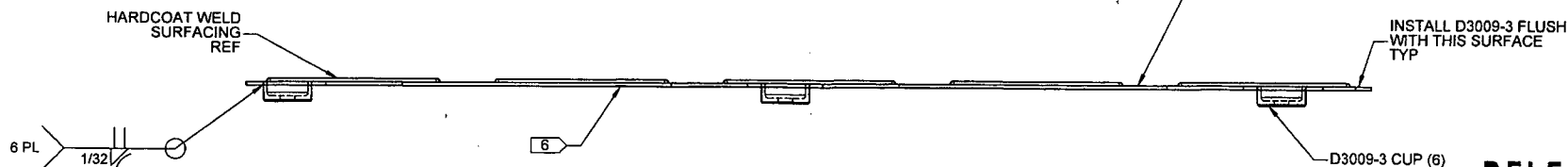
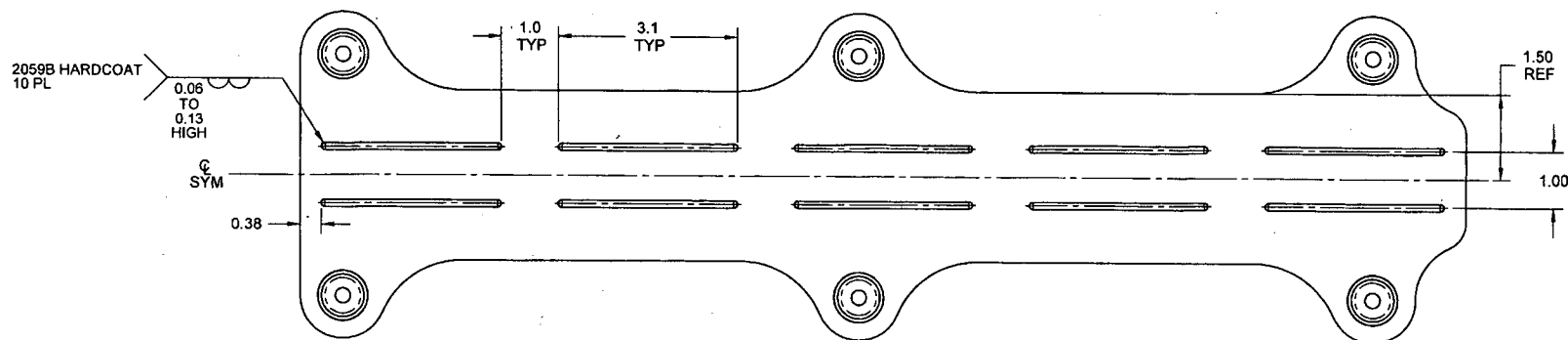
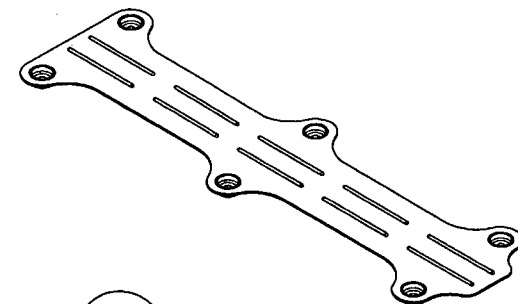
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NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3859-041	WEARPLATE
2	1	D3859-1	WEARPLATE
3	6	D3009-3	CUP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60560
880-714



D3859-041 WEARPLATE

RELEASED
09.01.26

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3859-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.46 lbs
- 8) WELD PER DART QSI 004

A	NEW ISSUE		09.01.26
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.26		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3859

REV. A
SHEET 1 OF 2

TITLE
WEARPLATE

SCALE
NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

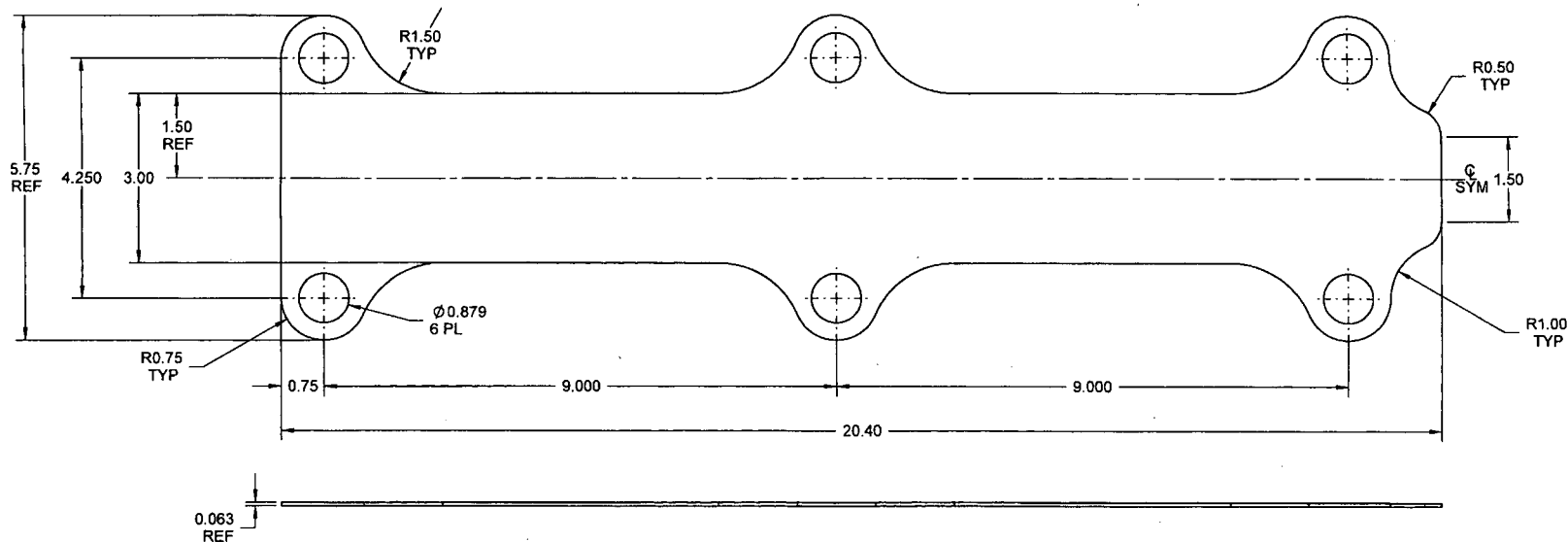
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Wto 60560



D3859-1 WEARPLATE

RELEASED
09.01.26

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK), PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 (REF DART SPEC M304S16GA)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.29 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3859	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	09.01.26	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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